

Date: Friday, 18/07/2008 1:10:23 PM
 *User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABIN FLOOR PROTECTOR
Job Number	: 40649		
Estimate Number	: 12970		
P.O. Number	:	Part Number	: D35746
This Issue	: 18/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3574 REV.A
First Issue	: / /	Project Number	: N/A
Previous Run	: 38518	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 31/07/2008
Checked & Approved By	: <u>JUL 08.7.18</u>	Qty:	2 Um: Each
Comment	: Est Rev :A New Issue 07.07.23 EC verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
-----	------------------	-------------------------



Comment: Qty.: 33.6000 sf(s)/Unit Total : 67.2000 sf(s)

lexan sheet

Batch: 105330 B 8-7-23

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: AProg Rev: AB 8-7-232

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B 8-7-23**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK8 08/07/23 (2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 08/07/26(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:10:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 40649

Part Number: D35746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/07/29 (47)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: PPP 8/7/29

50
27

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/30

Job Completion



mf 08-07-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40649
Description: Cabin Floor Protector		Part Number: D3574-6
Inspection Dwg: D3574	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	*		Tape M.	
7.38	+/-0.030	7.38	*			
11.00	+/-0.030	11.00	*			
15.25	+/-0.030	15.25	*			
25.87	+/-0.030	25.87	*			
39.75	+/-0.030	39.75	*			
44.75	+/-0.030	44.75	*			
58.38	+/-0.030	58.38	*			
63.50	+/-0.030	63.50	*			
65.25	+/-0.030	65.25	*			
10.25	+/-0.030	10.25	*			
11.87	+/-0.030	11.87	*			
14.75	+/-0.030	14.75	*			
26.00	+/-0.030	26.00	*			
40.87	+/-0.030	40.87	*			
45.00	+/-0.030	45.00	*			
48.00	+/-0.030	48.00	*			
55.13	+/-0.030	55.13	*			
61.25	+/-0.030	61.25	*			
61.88	+/-0.030	61.88	*			
64.63	+/-0.030	64.63	*			
1.13	+/-0.030	1.13	*			
7.63	+/-0.030	7.63	*			
11.00	+/-0.030	11.00	*			
22.10	+/-0.030	22.10	*			
22.50	+/-0.030	22.50	*			
24.50	+/-0.030	24.50	*			
35.13	+/-0.030	35.13	*			

08/07/23

DART AEROSPACE LTD		Work Order: 140649
Description: Cabin Floor Protector		Part Number: D3574-6
Inspection Dwg: D3574	Rev: A	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.50	+/-0.030	36.50	X		Tape	
40.00	+/-0.030	40.00	X			
41.88	+/-0.030	41.88	X			
43.63	+/-0.030	43.63	X			
6.75	+/-0.030	6.75	X			
9.50	+/-0.030	9.50	X			
10.38	+/-0.030	10.38	X			
14.50	+/-0.030	14.50	X			
16.75	+/-0.030	16.75	X			
18.94	+/-0.030	18.94	X			
19.00	+/-0.030	19.00	X			
24.13	+/-0.030	24.13	X			
33.88	+/-0.030	33.88	X			
39.50	+/-0.030	39.50	X			
40.25	+/-0.030	40.25	X			
43.50	+/-0.030	43.50	X			
46.60	+/-0.030	46.60	X		Tape	

Measured by: RB
Date: 8-7-23

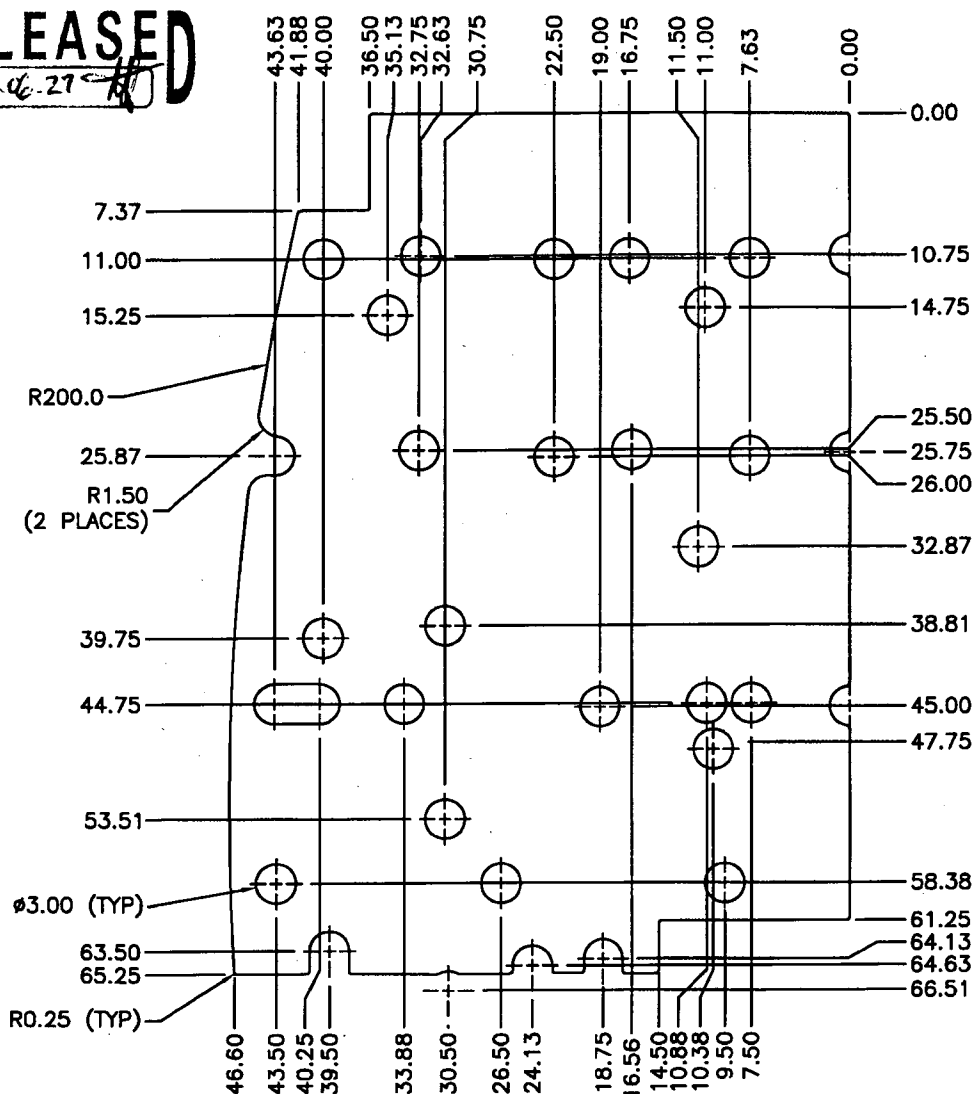
Audited by: S
Date: 8/7/23

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07.06.27

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WORK ORDER
NO. 40649

D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)**NOTES:**

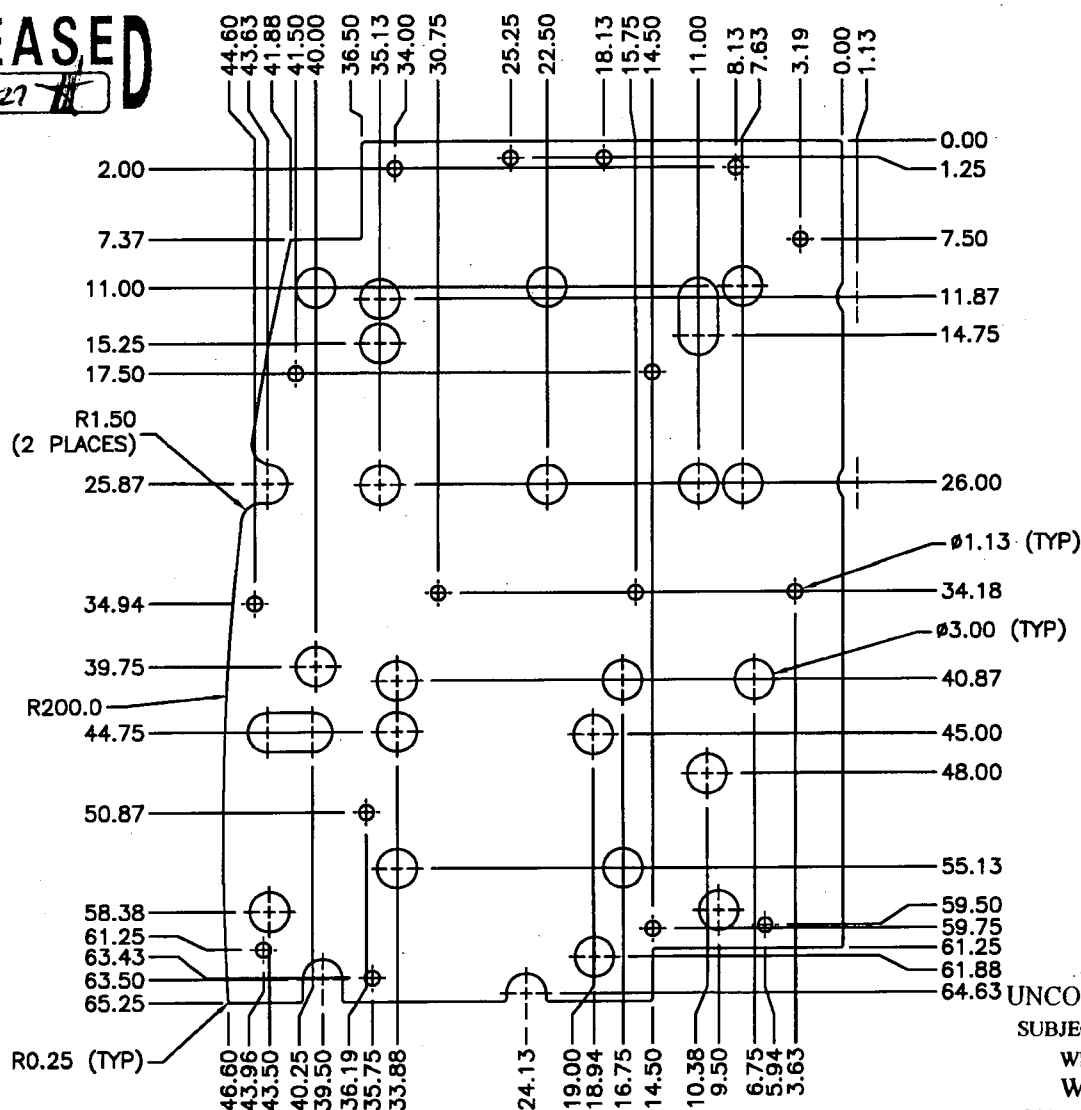
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

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07.06.08

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D3574-3 CABIN FLOOR PROTECTOR**NOTES:**

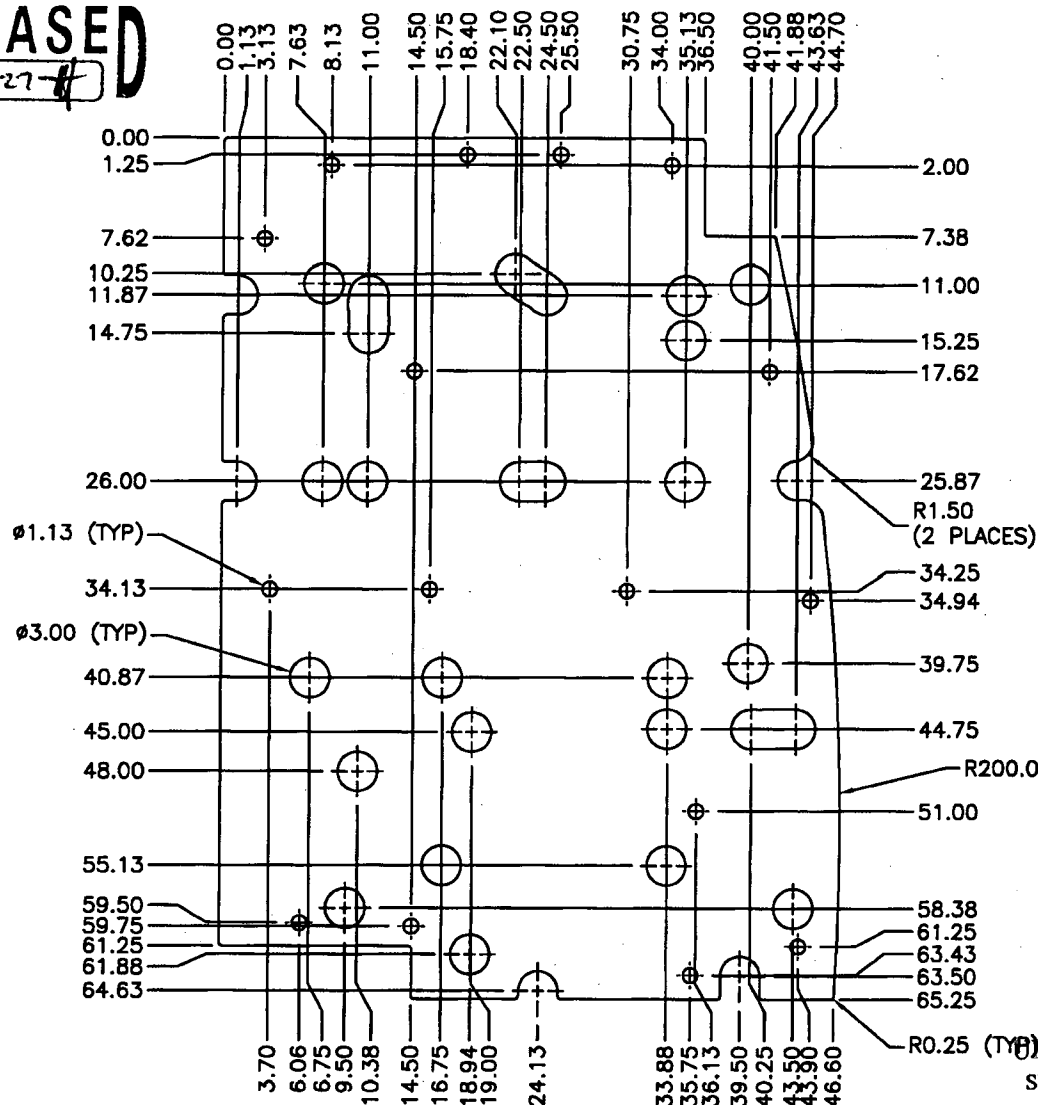
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

RELEASED
07.06.27**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

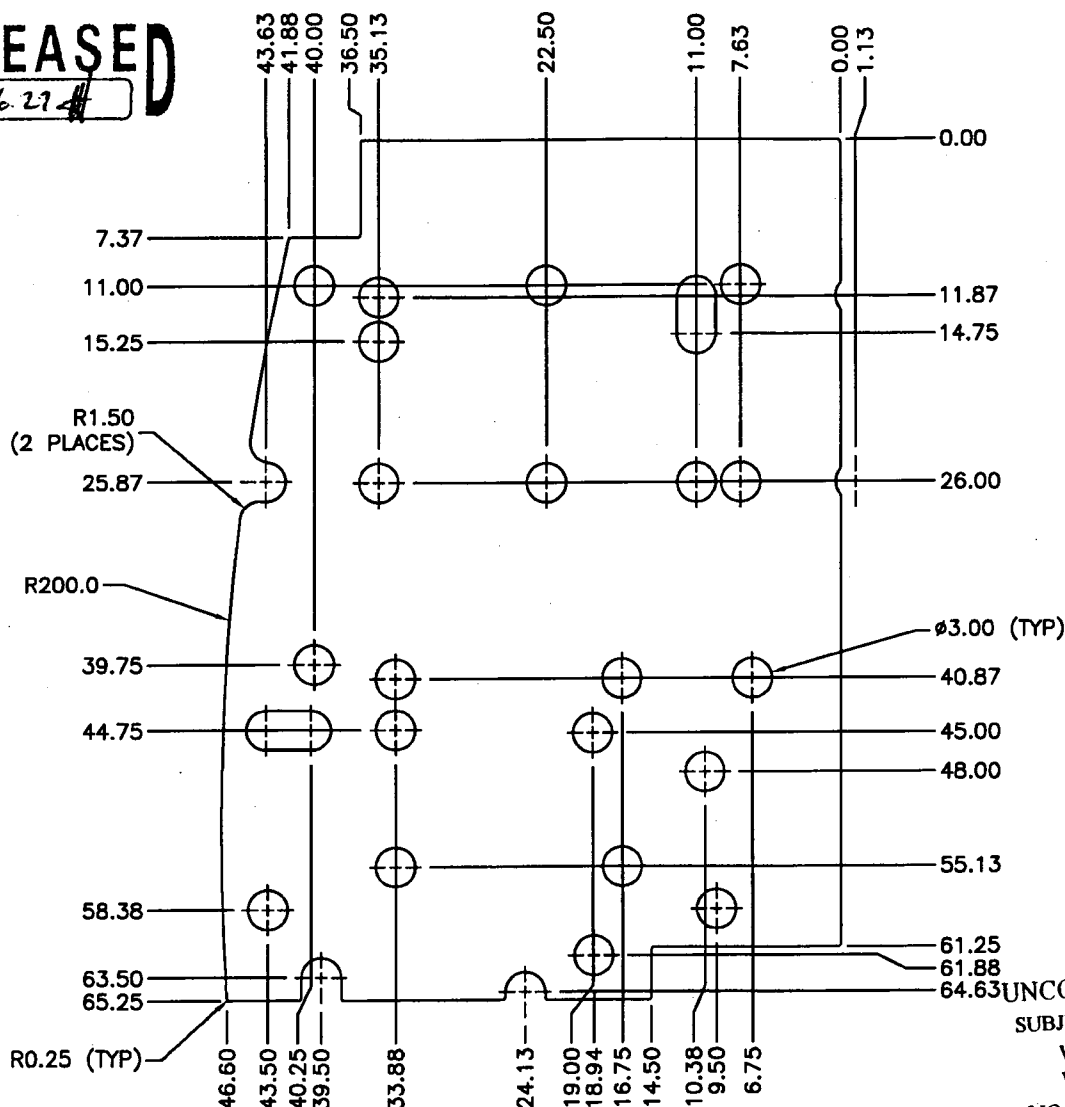
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27.4**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

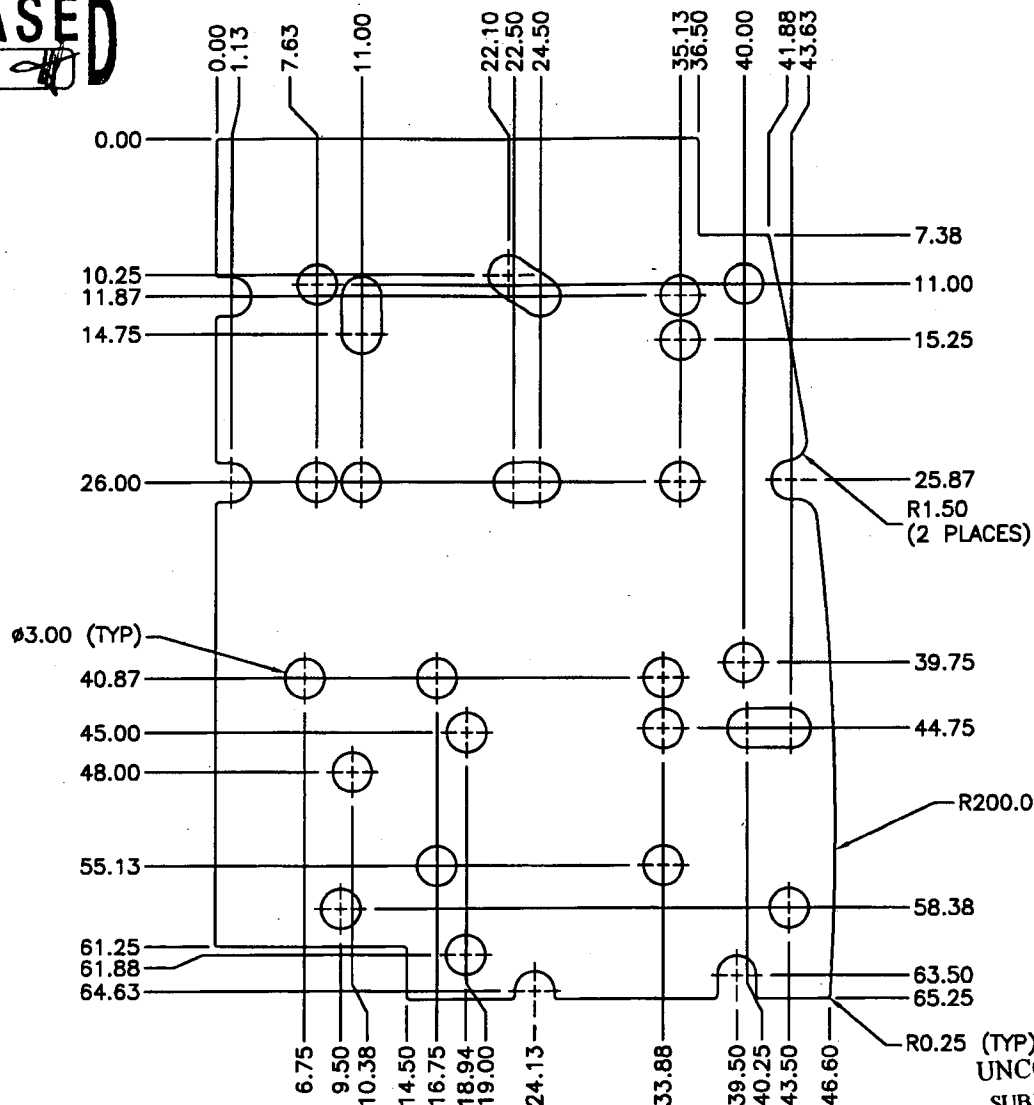
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27 *[Signature]***D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
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